

Work Order ID 69819



Page 1

Thursday, May 19, 2011 2:32:34 PM

Item ID: D3492-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug

Start Date: 5/19/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/25/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 5/19/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3492

00/R

100

0.00



Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per Folio FA633 & Dwg D3492

Dwg Rev:

Folio Rev: N/A

W 5/31

100 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

W 5/31

100 0

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

W 5/31

100 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Revision ID:

Stop



Item Name: Plug

Start Date: 5/19/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/25/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00				100	0		
Small Fab	Memo 1-Deburr if necessary 2-Tumble	0.00		11/5/31					
140 QC	QC5- Inspect part completeness to step on W/O	0.00				100	0		
Quality Control	Memo	0.00		11.05.31					
150 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				100			
Hand Finishing	Memo	0.00						BR 11-5-1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69819



Page 3

Thursday, May 19, 2011 2:32:34 PM

Item ID: D3492-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug

Start Date: 5/19/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/25/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

(Flat End Only)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:45
320°F
12:15

100 ☒ M/L 11/06/06

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

100 ☒ Jll 11/06/06

180



Packaging

Packaging

Identify as per dwg & Stock Location: F2-13

0.00

Memo

0.00

100 ☒ Jll 11/06/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69819

Page 4

Thursday, May 19, 2011 2:32:34 PM

Item ID:	D3492-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Plug					
Start Date:	5/19/2011	Start Qty:	100.00		Cust Item ID:	
Required Date:	5/25/2011	Req'd Qty:	100.00		Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:		Run	Start
	QC:	Date:	SPC (Y/N):			Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/6/79
11-06-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 19, 2011 2:32:40 PM

Page 1

Work Order ID: 69819

Parent Item: D3492-1

Parent Item Name: Plug



Start Date: 5/19/2011

Required Date: 5/25/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased	No			100	f	90.0000	0.0625	6.578947			
6061-T6 Round Bar .625"													

SD WS/31

Location	Loc Qty	Loc Code
MAT012	90	
117284	53	
117481	37	

GR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	69819
Description: Plug		Part Number:	D3492-1
Inspection Dwg: D3492 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

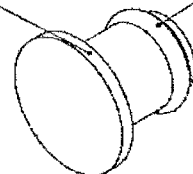
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	.060	/		2-9	
0.060	+/-0.005	.059	/			
Ø0.394	+/-0.010	Ø.394	/			
Ø0.625	+/-0.010	Ø.623	/			
0.090	+0.000/-0.002	.090	/			
0.500	+/-0.010	.500	/			
0.055	+0.000/-0.002					
0.050 x 20°	+/-0.010	.050 x 20°	/			
.050	+0.000/-0.002					Reu D

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 11/5/31	Date: 11-5-21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.02	New Issue P/O D3492-041	KJ/JLM	
B	06.10.16	Ø0.625 was Ø0.500	KJ/JLM	
C	07.11.23	Tolerances revised	KJ/EC/DD	
D	08.06.19	0.050 x 20° dimension added	KJ/DD 	

D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)



w/o 69819

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
							NAS1611-005	O-RING
				1			NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

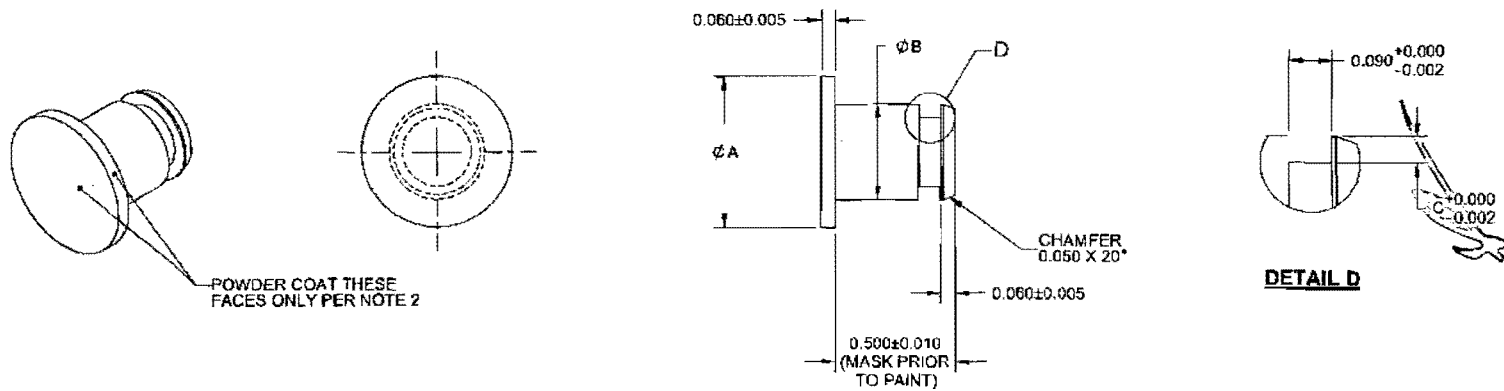
NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

RELEASED
2011-05-30

D	INCORPORATED DEC D3492-C-1, SHT 2 DIM C FOR -1 WAS 0.053 (SEE PART 11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047, UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A	DRAWING NO.	REV. D
MFG. APPR.	JER	D3492	SHEET 1 OF 2
APPROVED	ALB	TITLE	SCALE
DE APPR.	7	PLUG	2:1
DATE	11.05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE ON THE INTERNET WITHOUT RESTRICTIONS UNLESS OTHERWISE INDICATED BY A NOTICE TO THE CONTRARY	

8 7 6 5 4 3 2 1



D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC	
D3492-1	0.625	0.394	0.050	M6061T6R0.625	△
D3492-3	0.750	0.582	0.045	M6061T6R0.750	
D3492-5	0.375	0.188	0.045	M6061T6R0.375	
D3492-7	0.500	0.270	0.045	M6061T6R0.500	
D3492-9	0.938	0.750	0.045	M6061T6R1.000	
D3492-11	0.850	0.664	0.045	M6061T6R0.875	
D3492-13	0.750	0.510	0.045	M6061T6R0.750	△

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
2011-05-30
JAW

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	JES	D3492	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	4:1
DATE	11.05.24	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THE SYSTEMS DESIGN, INVENTION, AND CONCEPTS OF THE DART AEROSPACE LTD ARE NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

